



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400220
Job Sheet 195335



Part No: RBT400220

Job Qty: 2 pcs

Part Name: Wrench Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/17/19

Job Tracking No:

Due Date: ~~6/7/19~~ 6/19/2019

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBT400220 Rev.1B IPP Rev. A 18.08.02 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	6/7/19	6/7/19	0.00	0.00	Purchasing - 1		DP JUN 19 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	6/7/19	6/7/19	0.00	0.00	Packaging 2 - 1 - B4B		DP JUN 19 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S191774



Part: RBT400220

Job No: 195335

Serial No/Batch: S191774

Revision: 1B

Inspector:

Exp Date:

Instructions:

Date: 06/19/19

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	6/7/19	0.00 0.00	QC 6 - 9		
				QC 6 - 68		
				QC 6 - 61		DAS 40
				QC 6 - 40		JUN 19 2019 9-89
130 Packaging 3-1 - Stock - B4B	2 pcs	6/7/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		DAS 28
				Packaging 3 - 7 - B4B		9-89
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140 QC 21 - FG	2 pcs	6/7/19	0.00 0.00	QC 21 - FG - 21	DAS	
				QC 21 - FG - 70	21	JUN 20 2019
				QC 21 - SA - 53	9-89	

Part Op 100 - (Purchasing) Issue PO to P.J. MACHINAGE P/O 0043488 MANUFACTURE RBT400220 AS PER DWG -
 Descriptions: Certificate of conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBT400220P	Wrench Assembly	2 pcs (1 ea)	100-Purchasing	5191767
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT400220P	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 5/17/19 9:46 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043488



Supplier: PJM001-VC
P.J. Machinage
1381 Rte Cite-Des-Jeunes
St-Lazare
QC
J7T 2B8
Phone: 450-455-0705

PO No: POHB043488
PO Date: 5/17/19
Due Date: 6/7/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195335	RBT400220P	XZ		Wrench Assembly REV 1B	Firmed		6/7/19 JUN 19 2019	2 pcs 6/17/2019	0 pcs	2 pcs	\$0.01/pcs	\$0.02
Line Item Note No charge PO , to replace units sent on PO042765													Grand Total: \$0.02

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 5/17/19 10:02 AM dart.Lussier.Patrick

Shipping Order

18/06/2019

P.J. Machinage (9052 9470 Qc Inc).
1381, Rte Cité-Des-Jeunes,
St-Lazare, Qc
J7T 2B8

Tel. : 450 455-0705

Order : 7940
Reference : POHB043488-S/O:7940

Customer : 628

Ship To

Dart Aerospace Ltd.
Accounts payable
1270 Aberdeen St
Hawkesbury, Ontario
K6A 1K7

Same

Tel.: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
C628/RBT400220P	Wrench Assembly Part # RBT400220P Rev. 1B Rework of PO042765 NO/CHARGE	2	<u>2</u>	<u>P</u>

RECEIVED
JUN 19 2019
DART AEROSPACE LTD.

P.J. Machinage retains ownership of all goods sold and other work-product delivered to or performed for its customer until full and complete payment of the underlying invoice, even in circumstances where the part to be machined or materials were provided by the customer. In cases where the part of materials belonged to the customer before it is remitted to P.J. Machinage for the purpose of performing work thereon, its delivery to P.J. Machinage shall entail a transfer of the underlying rights of ownership of the customer over said part or materials.

Shipping : Yerw truck
Package No : _____
Merchandise Received : 106/2019

Ref. : _____

PJ Machinage

Certificate of conformance

Sold to:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON, K6A 1K7

Supplier address:

PJ Machinage
1381 Route Cité-Des-Jeunes
St-Lazare, Qc, J7T 2B8

Purchase Order: POHB043488

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This is to certify that the below names items were inspected and/or tested to your drawings, specifications and purchase order. Objective evidence are shipped with the products and are on file to support the verifications and/or tests and can be made available on request, unless otherwise noted.

<u>Part Number</u>	<u>Quantity</u>	<u>Description</u>
RBT400220P Rev. 1B	2	Wrench Assembly


_____, June 18, 2019

PEJ MACHINAGE

CONTRÔLE DE QUALITÉ

WRENCH

MATÉRIEL: 4/40 Ann (Heat treat)

OBSERVATION: _____

SIGNATURE RESPONSABLE:

Benoit Mayer

CLIENT: 628
 JOB No.: 7940
 PLAN No.: RB-460220 Rev 1B
 P.O.: PO4B043488
 QUANTITÉ: 2 NOM DE LA

QUANTITÉ: 2 NOM DE LA PIÈCE:

WRENCH

MATÉRIEL:

PAGE No.: 2/2

[illegible]

OBSERVATION:

SIGNATURE RESPONSABLE:

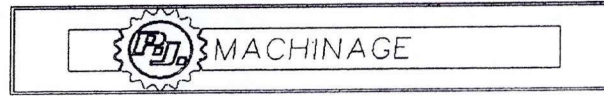
Benoit Mayer

Rough machining

predicted

Mesure after Heat treat Before Machining.

CLIENT: 628
JOB No.: 7940
PLAN No.: RBTH00220 1B
P.O.: POHBO43488
QUANTITÉ: 2



CONTRÔLE DE QUALITÉ

DATE: _____
FORMAT No.: 001
PAGE No.: _____

NOM DE LA PIÈCE:

WRENCH

MATÉRIEL: 4140 Ann.

DIMENSIONS DE DESSIN ET TOLERANCE

PIÈCE No.	1.00	.53	4.50 ϕ	4.90 ϕ	3.500 ϕ	2.00	1.009 ϕ		
					7/- .002		1.004 ϕ		

DIMENSIONS DE LA PIÈCE

1	1.040	.610	4.598	4.994	3.393	2.103	.903		
2	1.040	.606	4.597	4.996	3.397	2.100	.904		

OBSERVATION: _____

SIGNATURE RESPONSABLE:

Benoit Mayr



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020048- 1

Livré à / Ship to

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes

St-Lazare, QC, J7T2B8

CANADA

Tel.: 450-455-0705 Fax.: 450-455-1167

Client / Customer:

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes

St-Lazare, QC, J7T2B8

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
18-Jun-2019		Jessie Boisvert		136639					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBT400220 Rev.	WRENCH 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416F, TYPE II, CLASS II: *** 02- BAKE	CADMIUM CH	2	2	0	0	0	

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



ACIER VANGUARD LTÉE

2205 de l'Aviation, DORVAL, QUÉBEC, Canada, H9P 2X6.

Tel: (514) 685-1515 fax: (514) 685-1516

CERTIFICATE OF COMPLIANCE / CERTIFICAT DE CONFORMITÉ

Order No. / No. Commande 136456	CUSTOMER / CLIENT P.J. MACHINING	Packing slip / No. d'expédition L69399-01	DATE 21-05-19
MATERIAL ID# / No. MATÉRIEL 2019-1429	GRADE / NUANCE AISI 4140	HEAT TREATMENT / TRAITEMENT THERMIQUE ANNEALED / RECUIT ADOUCI	HEAT / COULÉE U9546-1
PAYS D'ORIGINE:	U.S.A.		
SHAPE / FORME Plate / Plaque	SIZE / DIMENSION 1.000" in.	SPECIFICATIONS ASTM A829	

CHEMICAL COMPOSITION / ANALYSE CHIMIQUE							
	Carbon (C)		Silicon (Si)		Manganese (Mn)		Phosphorus (P)
mini/maxi	0.380	0.430	0.150	0.350	0.750	1.000	0.035
actuel (%):	0.400		0.240		0.810		0.012
	Sulfur (S)		Chromium (Cr)		Nickel (Ni)		Molybdenum (Mo)
mini/maxi	0.040		0.800	1.100	0.000	0.250	0.150 0.250
actuel (%):	0.008		0.910		0.140		0.170
	Copper (Cu)		Vanadium (V)		Aluminium (Al)		Tungsten (T)
mini/maxi	0.350		---		---		---
actuel (%):	0.190		0.003		0.007		0.000

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MECHANICAL PROPERTIES / PROPRIÉTÉS MÉCANIQUES				
Yield strength / Élasticité	Tensile / résistance à la traction	Elongation / allongement (%)	Reduction of area / surface (%)	surface hd / dureté
PSI	PSI	.	0.0%	204-219 BHN

TESTS JOMINY / JOMINY RESULTS					
J	HRC	J	HRC	J	HRC
01	.	07	.	13	.
02	.	08	.	14	.
03	.	09	.	15	.
04	.	10	.	16	.
05	.	11	.	18	.
06	.	12	.	20	.
				22	.
				24	.
				26	.
				28	.
				30	.
				32	.

No weld repairs performed during the manufacturing of this product. We hereby certify that the above results have been verified and conform to the above mentioned specifications. Material is Mercury free, without radioactivity.

Aucune réparation exécutée par soudure durant la fabrication de ce produit. Par la présente nous attestons que les résultats ci-haut mentionnés ont été vérifiés et sont conformes aux spécifications. Pas de contact au Mercure, sans radioactivité.

Keith BALL - Branch Manager

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
336866	1

CLIENT / customer 236

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

LIVRÉ À / shipped to:

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
136523	N/A	4140		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

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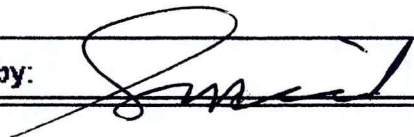
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
RDNESS	32 - 37 HRC	2 (907)	34 - 35 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
2	8	PIECES (2) PIECES 1 BC EPS

10/6/19

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2019-06-01

PAYÉ

C.O.D.

APPROUVÉ